

Date: Monday, 1/7/2008 11:33:34 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BAFFLE ASSEMBLY
Job Number : 36596	
Estimate Number : 11264	
P.O. Number :	Part Number : D3276041
This Issue : 1/7/2008 S.O. No. :	Drawing Number : D3276 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 36502	Material :
Written By : <u>HB 08.01.07</u>	Due Date : 1/31/2008
Checked & Approved By : <u>HB 08.01.07</u>	Qty: <u>12</u> Um: Each
Comment : Est Rev:A New Issue 05-12-06 JLM	
Est Rev:B Now on Waterjet 06-09-06 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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12-8583



Comment: Qty.: 1.0715 sf(s)/Unit Total : 10.7153 sf(s)

Material: 6061-T6 (QQ-A-250/11) 0.040" thick

(M6061T6S.040)

Batch: 106747

HB 8-1-10

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3276

Dwg Rev: B

HB 8-1-10

Prog Rev: B

(12)

2-Deburr if necessary

HB 8-1-10

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 8-1-10



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

HB 08/01/15 (12)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Roll as per Dwg D3276

HB 08/01/15 (12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 11:33:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAFFLE ASSEMBLY

Job Number: 36596

Part Number: D3276041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3276

SBS 08/01/15

(12)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6 08/01/15 (x12)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-01-16

(12)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M/06379

FL 08/01/17

(12)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 08-01-17

(12)

11.0

D2464

3/4 Seal



Comment: Qty.: 2.2500 f(s)/Unit Total : 22.5000 f(s)

Pick:

Qty Part Number Description Batch

27.0" D2464 Neoprene Seal B335433

AS 08/01/18

(x12)

12.0

D32763

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3276-3 Decal 36523x9 B36633

AS 08/01/18

(x12)

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3276

SBS 08/01/21

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 11:33:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAFFLE ASSEMBLY

Job Number: 36596

Part Number: D3276041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AS *08/01/22* *(12)*

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *SI 179*

AS *08/01/22* *(12)*

16.0

QC21

FINAL INSPECTION/W/O RELEASE



08.01.23 *AS*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mi 20081/23
W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	36596
Description: Baffle		Part Number:	D3276-1
Inspection Dwg: D3276 Rev: B		Page 1 of 1	

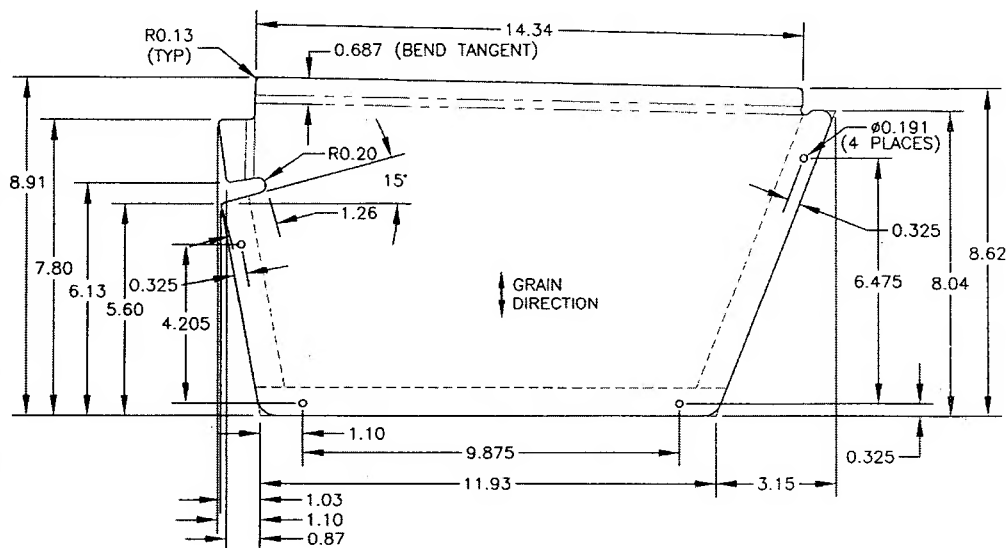
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.34	+/-0.030	14.34	X			
8.62	+/-0.030	8.62	X			
8.04	+/-0.030	8.04	X			
Ø0.191	+0.005/-0.000	.193	X			
0.325	+/-0.005	.325	X			
11.93	+/-0.030	11.93	X			
9.875	+/-0.005	9.875	X			
5.60	+/-0.030	5.62	X			
7.80	+/-0.030	7.80	X			
8.91	+/-0.030	8.91	X			
1.26	+/-0.030	1.26	X			
Grain Direction	N/A	Good	X			

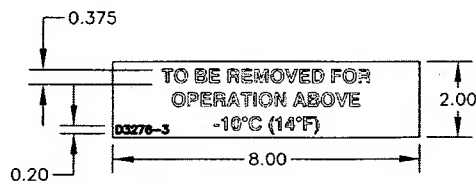
Measured by:	VB	Audited by:	J	Prototype Approval:	N/A
Date:	8-1-9	Date:	08/01/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue P/O D044-717-011	KJ/JLM	<i>[Signature]</i>



D3276-1 BAFFLE (FLAT PATTERN)

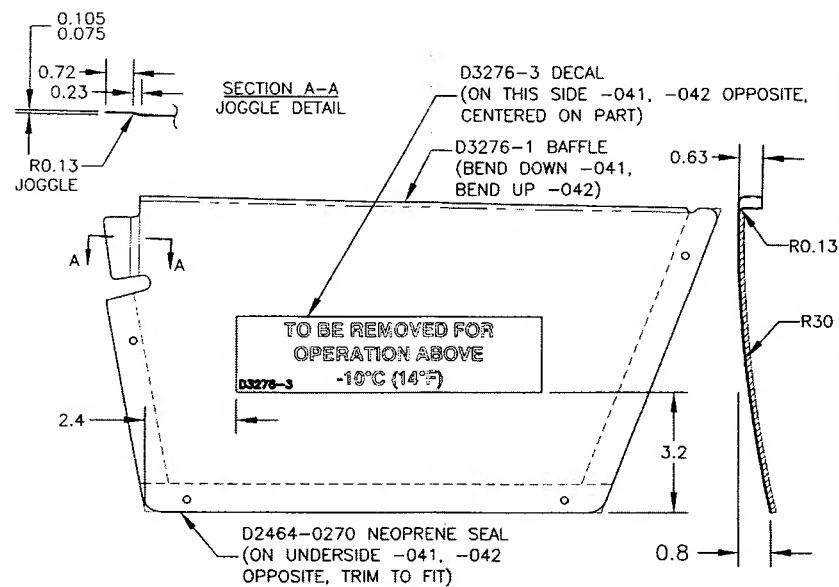
- 1) MACHINE PER DWG FILE "D3276-A.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11)
(REF DART SPEC. M6061T6S.040)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3276-3 DECAL

- 1) RED LETTERING ON WHITE ADHESIVE BACK
- 2) MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 36576
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY



D3276-041 BAFFLE ASSEMBLY, LH (SHOWN)

D3276-042 BAFFLE ASSEMBLY, RH (BEND/JOGGLE OPPOSITE)

RELEASED
05.02.02

B	05.01.25	LABEL NOW -10°C; CURVE PART
A	05.01.07	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	#	APPROVED
DATE	05.01.25	
DART	DART AEROSPACE LTD.	
DRAWING NO.	D3276	REV. B
TITLE	BAFFLE ASSEMBLY	SHEET 1 OF 1
		SCALE 1:3

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